

Work Order ID 68670

Tuesday, April 19, 2011 3:57:03 PM



Page 1

Item ID:	D3049-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Bearpaw				Stop	
Start Date:	4/19/2011	Start Qty:	4.00			
Required Date:	4/25/2011	Req'd Qty:	4.00			
Reference:						

Approvals:	Process Plan:	Date:	4-19-11	Tooling:		Date:		Run	Start	
	QC:	Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3049	Rev A1

110		0.00							
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT BLANK AS PER FILE D3049-1_BLANK								

11-4-25

(u)

120		0.00							
HAAS 1	HAAS CNC VERTICAL MACHINING #1	0.00							
HAAS CNC vertical machine #1	Memo	0.00							
	1-Inspect material for defects or damage prior to machining								
	2-Machine as per Folio FA165 and Dwg D30491 identify as D3049-1								
	3-Deburr								

F.K. / R 11. 7. 14

4

0

130		0.00							
QC	QC2- Inspect parts off machine FA1/FA1B	0.00							
Quality Control	Memo	0.00							

F.K. / R 11-7-14

4

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68670

Tuesday, April 19, 2011 3:57:03 PM



Page 2

Item ID: D3049-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 4/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/09/15

4 0

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

Memo

PPP 68667

0.00

Packaging

11/09/15

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/19/19

MF
11-09-16

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 19, 2011 3:57:08 PM

Page 1

Work Order ID: 68670

Parent Item: D3049-1

Parent Item Name: Bearpaw




Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	227.0000	3.4	13.6			



B11-4-05

Location

Loc Qty

Loc Code

MAT018

227

116554

2

117321

225

117321

(4)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	68670
Description: Bearpaw		Part Number:	D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A Ø0.260	+0.005/-0.000	.260	/	/	RQ. 02	
B 0.93	+/-0.030	.923	/	/	RQ. 17	
C 0.40	+0.030/-0.000	.408	/	/		
D 2.00	+/-0.030	1.996	/	/		
E 10.250	+/-0.010	10.252	/	/		
F 4.540	+/-0.030	4.540	/	/		
G 5.88	+/-0.030	5.876	/	/		
H 0.38	+/-0.030	.377	/	/		
I 11.50	+/-0.030	11.50	/	/		
J 0.07 x 45°	+0.030/-0.010	.06	/	/		
K 0.44 - 0.47	+/-0.000	.460	/	/		
L R0.25	+/-0.030	.25	/	/		
M 0.38	+/-0.010	.384	/	/		
N 0.95	+0.030/-0.010	.962	/	/		
O 0.69	+/-0.030	.697	/	/		
P 0.20	+/-0.030	.200	/	/		
Q 23.00	+/-0.030	23.00	/	/		
R 0.25 x 45°	+/-0.030	.240	/	/		

Measured by: <i>PK/KK</i>	Audited by: <i>B.A</i>	Prototype Approval:	N/A
Date: <i>11-9-14</i>	Date: <i>11/09/15</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	<i>[Signature]</i>

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NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	# 03.01.13	Ø 0.93 WAS Ø 0.75	

RELEASED
01.10.24

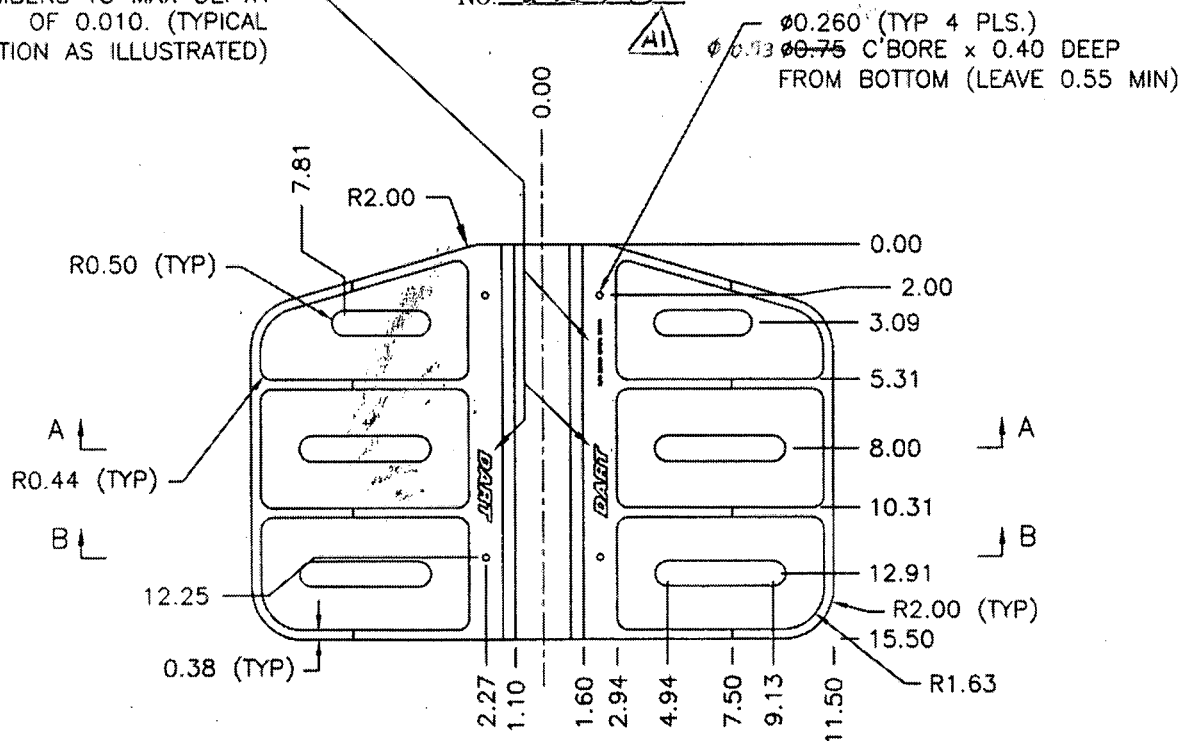
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 28670

BF 11-04-19

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

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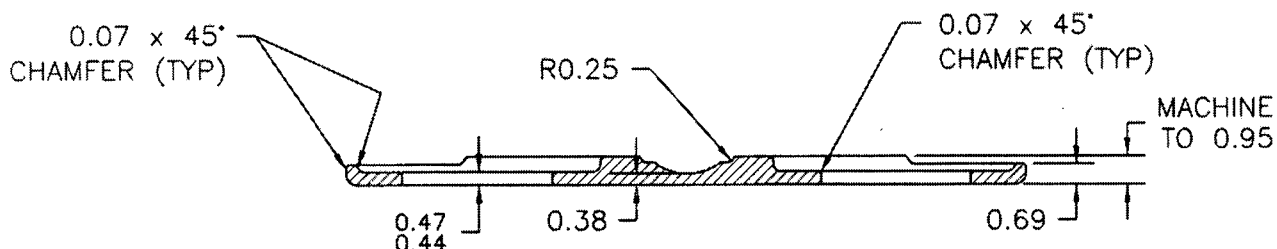
NOTE: Date & initial all entries



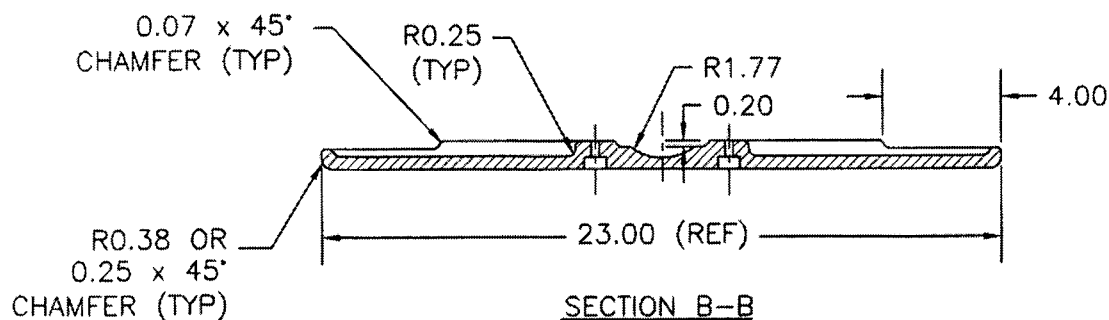
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 *[Signature]*

wb 68670



SECTION A-A



SECTION B-B

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